Work Order ID 64920

Thursday, December 23, 2010 10:16:26 AM

Item ID: D2327-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Spacer Bushing

Start Date: 12/23/2010 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 12/30/2010 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** ___ **Date:** 10/12/23 **Tooling:** ___ **Date:** ___ **Run Start** **Stop**

QC: ___ **Date:** ___ **SPC (Y/N):** ___ **Date:** ___

Draw Nbr	Revision Nbr
D2327	Rev D

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Hardinge CNC LATHE SMALL	0.00				20	Ø		
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn per Folio FA232 and Dwg D2327 ☐Deburr								
		11/1/04							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				20	Ø		
QC	Memo	0.00							
Quality Control		11/1/04							
120	QC8- Inspect parts - second check	0.00				20			
QC	Memo	0.00							
Quality Control		11.1.4							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WA	0.00							
Packaging		SAD 11-01-11				20			
Packaging	**Memo** *****STOCK IN BASKET CELL*****	0.00							
140	QC21- Final Inspection - Work Order Release	0.00					11/01/12		
QC	**Memo**	0.00							
Quality Control									

11-01-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 23, 2010 10:16:30 AM

Work Order ID: 64920

Parent Item: D2327-3

Parent Item Name: Spacer Bushing

Start Date: 12/23/2010 **Required Date:** 12/30/2010

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP F□05.11.02□Removed 303 SS□KJ/EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375 304 ROUND BAR 0.375		Purchased	No			100	f	20.9085	0.1563	3.290526	3.5	10/1/09	

Location	Loc Qty	Loc Code
MAT	15.5685	
111323	0	
114467	~~5.1~~	
114676	~~1.2~~	
115180	~~4.7~~	
115334	7.6685	3.5
MAT029	~~5.34~~	
113325	~~3.85~~	
114356	~~1.49~~	

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	64920
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327 **Rev:** D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	Ø.376	✓		Vela	SA-9
Ø0.257	+0.005/-0.000	Ø.258	✓			
1.750	+/-0.010	1.749	✓			

Measured by:	SA	Audited by:	KD	Prototype Approval:	N/A
Date:	11/1/04	Date:	11.1.4	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	

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NOTE: Date & initial all entries

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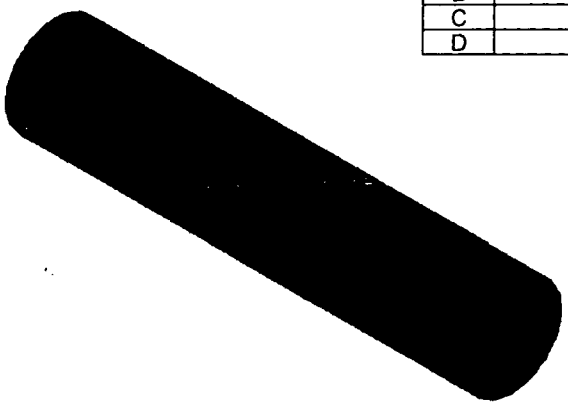
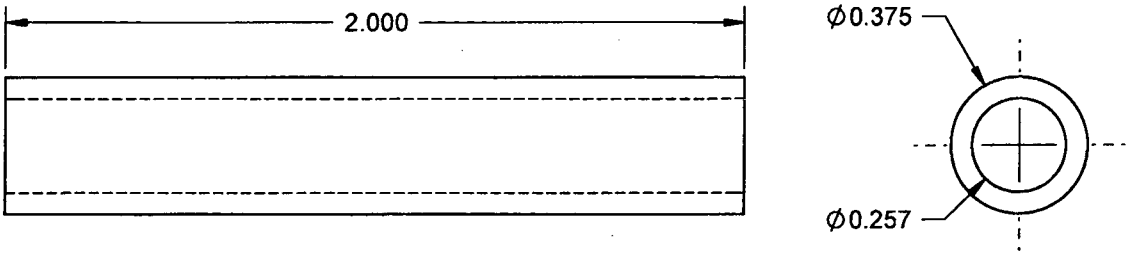
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW	CB		
CHECKED	APPROVED	DRAWING NO.	REV. D
LE		D2327	SHEET 1 OF 1
DATE		TITLE	SCALE
06.10.12		SPACER BUSHING	2:1

REV	DATE	DESCRIPTION
A	94.12.17	NEW ISSUE
B	95.12.06	LENGTH CHANGE
C	03.05.13	303 SS SPEC ADDED
D	06.10.12	REMOVE 303 SS MATERIAL

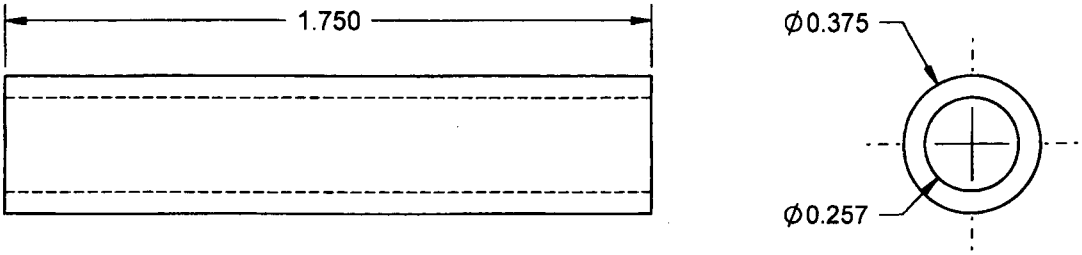


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 04920
12-12-23

RELEASED
06.11.14



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:
1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS TO 0.010 MAX

D

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